

Work Order ID 140268-2

December 18, 2015 2:52:16 PM

140268

To ship Jan 7 & 11th

Page 1

Item ID: D412-775-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Protective Trim

Stop *NS2*

Start Date: 12/18/2015 Start Qty: 6.00

Required Date: 1/15/2016 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *SA*

Date: 0151218

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9503

A

IIN D412-775

Rev A

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-775-013 CHG003

mw 154221

DAS
28
9-88

MAR 07 2016

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

DAS
27
9-88

DEC 21 2015

6
1

Work Order ID 140268

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140268

Page 2

Item ID: D412-775-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Step Protective Trim

Stop

NS2

Start Date: 12/18/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 1/15/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC4- 100% Inspect kits for completeness

0.00

110

QC

Memo

0.00

Quality Control

DAS
28
9-89

MAR 07 2016

120

Packaging

0.00

120

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-775-013
Location: FG028DAS
28
9-89

MAR 07 2016

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.01

Quality Control

MUS

MAR 07 2016

MUS

MAR 07 2016

Picklist Print

December 18, 2015 2:52:22 PM

Page 1

Work Order ID: 140268

140268

Parent Item: D412-775-013

D412-775-013

Parent Item Name: Step Protective Trim

Start Date: 12/18/2015

Required Date: 1/15/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-10 new issue DD verified by:ec IPP Rev:B add pick
kit DD 10.02.18 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3608-1 *D.3608-1* Lower Doubler		Manufactured	No			110	Each	5.0000	1	5			AS 27 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST505			5					
					130504			5					
D3608-3 *D.3608-3* Upper Doubler		Manufactured	No			110	Each	6.0000	1	6			AS 27 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST505			6					
					130503			6					

DEC 21 2015

SH
20151218 130268

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0

REF. TCCA STC SH08-53
REF. FAA STC SR02692NY
REF. EASA STC EASA.IM.R.S.01529

It has come to Dart's attention that due to variances in airframe, the D3608-1/-3 Lower/Upper Doublers of the D412-775-013 Step Protective Trim Kit at CHG 001 may not always fit as intended. To ensure proper fit, Dart has made changes to both D3608-1/-3 Doublers at CHG 002 and later. The manuals listed above are amended as follows:

IS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\varnothing 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\varnothing 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

WAS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\varnothing 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

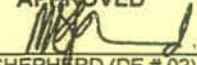
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\varnothing 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

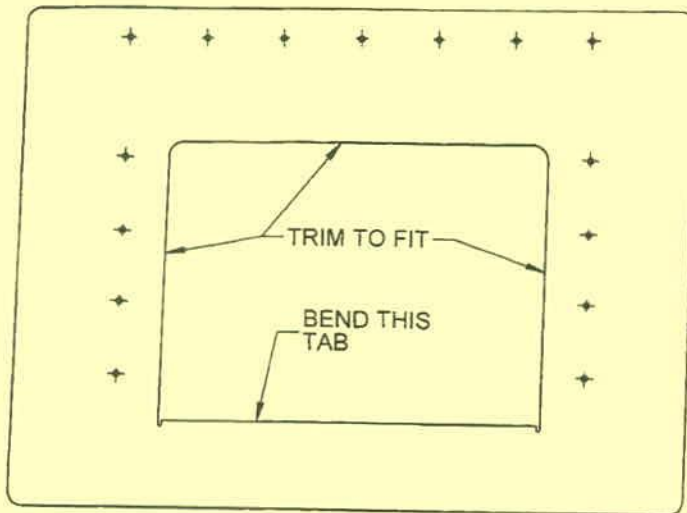
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

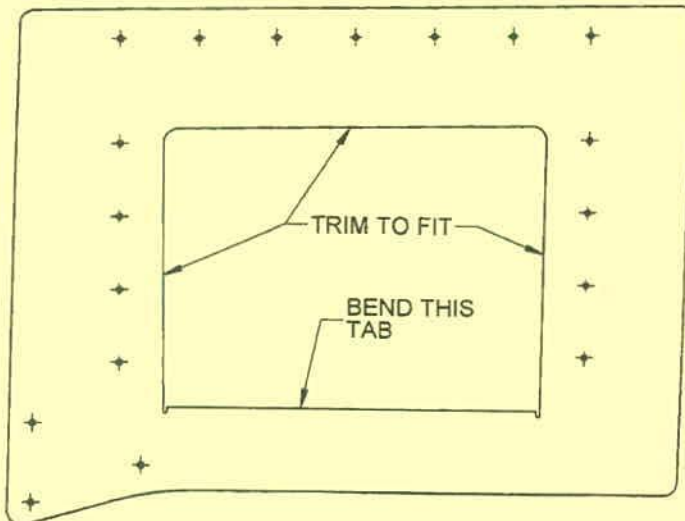
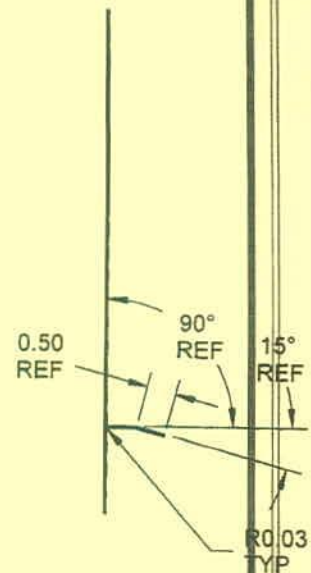
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.02.05
CERT. NO.: SH08-53
ISSUE NO.: 1

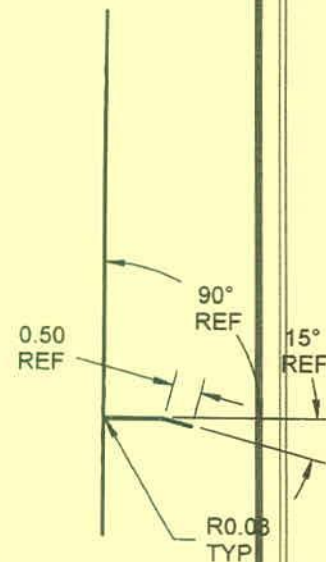
A	NEW ISSUE	MB	10.02.05
REV.	DESCRIPTION	BY	DATE
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 1 OF 2
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D3608-3 BENT UPPER DOUBLER



D3608-1 BENT LOWER DOUBLER



CANADA
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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.02.05
CERT. NO.: SH08-53
ISSUE NO.: 1

FIGURE 1: TRIMMING/BENDING OF D3608-1/-3 DOUBLERS
(PARTS SHOWN PRIOR TO TRANSFER DRILLING)

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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-775-011	DOOR SILL PROTECTIVE TRIM KIT
	X		D412-775-013	STEP PROTECTIVE TRIM KIT
		X	D412-775-015	FUEL PANEL PROTECTIVE TRIM KIT
2			D3602-1	ANGLE
	1		D3608-1	LOWER DOUBLER
	1		D3608-3	UPPER DOUBLER
		1	D3609-1	DOUBLER

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Revision: A
Date: 08.11.14